

# Work Order ID 66995

Thursday, March 03, 2011 10:16:51 AM

Page 1

Item ID: D350-600-249

Accept

Revision ID:

Item Name: Spacepod Upgrade

Start Date: 3/3/2011 Start Qty: 2.00

Required Date: 3/7/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 350-600-249 CHG001

8/10/13/09

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

Packaging

11/3/7 (2) J

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/13/09

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66995**

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Item ID: D350-600-249

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Upgrade

Start Date: 3/3/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-600-249 □ Location: _____ □ PPP Rev: <u>B</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/3/95 (20)

11/3/9  
CL11103109

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, March 03, 2011 10:16:57 AM

Page 1

Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 07.01.31 EC  
11.02.07 added missing AN960JD8 washer DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C832R24		Purchased	No			110	Each	70.0000	4	8			
Screw													

Location	Loc Qty	Loc Code
ST325	15	
115518	15	
ST327	55	
110179	5	
116556	50	

A3235-020-935		Purchased	No			120	Each	425.0000	1	2			
Washer - Countersunk													

Location	Loc Qty	Loc Code
ST281	425	
106150	425	

AN526C832R10		Purchased	No			120	Each	127.0000	10	20			
Screw													

Location	Loc Qty	Loc Code
ST327	127	
104603	3	
114382	24	
115101	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

AN526C832R14

Purchased

No

120

Each

512.0000

6

12



Screw



11/3/12

## Location

## Loc Qty

## Loc Code

ST327

512

104916

512

AN5-5A

Purchased

No

120

Each

75.0000

1

2



Bolt



11/3/12

## Location

## Loc Qty

## Loc Code

ST337

75

110865

75

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

24.0000

1

2



Washer



11/3/12

## Location

## Loc Qty

## Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16

AN960JD10L

NAS1149D0332J

Purchased

No

120

Each

4.0000

1

2



Washer



11/17/10 11/3/12 SL 2X

## Location

## Loc Qty

## Loc Code

ST335

4

11912

4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

S+1 AN960JD516 NAS1149D0563J Purchased No  
Washer

Location	Loc Qty	Loc Code
ST	34	
103694	18	
107534	12	
109287	4	

34.0000 4 8  
M116540 11/3/11

S+2 AN960JD8 NAS1149DN832J Purchased No  
Washer

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

10.0000 24 48  
M116857 11/3/11

S+2 D2228 Manufactured No  
Bracket Plate

Location	Loc Qty	Loc Code
ST009	42	
64427	42	

42.0000 2 4  
11/3/11

S+2 D2237 Manufactured No  
Striker Plate

Location	Loc Qty	Loc Code
ST009	81	
64426	3	
64762	14	
66139	64	

81.0000 1 2  
11/3/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

D2464

Manufactured No

120 f

551.5734 3

6315789



3/4 Seal



11/3/17 SP

## Location

## Loc Qty

## Loc Code

ST402

54.4734

48173

54.4734

ST404

497.1

61878

497.1

(D2464-0360) cut (1) at 36.00" per kit

D3015-3

Manufactured No

120 Each

234.0000 2

4



11/3/17 SP

Locknut

## Location

## Loc Qty

## Loc Code

ST030

234

60287

9

64275

25

66114

200

D3538-1

Manufactured No

120 Each

0.0000 2

4



B66018 11/3/17 SP

Hinge Bracket

D3547-1

Manufactured No

120 Each

4.0000 1

2



11/3/17 SP (20)

Bracket

## Location

## Loc Qty

## Loc Code

ST066

4

57951

4

2

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

D3550-1  
Strut

Manufactured No

120 Each

14.0000

1

2



11/3/7sf

Strut

Location

Loc Qty

Loc Code

ST271

14

56332

2

66019

12

2

D3552-7  
Door Prop

Manufactured No

120 Each

13.0000

1

2



11/3/7sf

Door Prop

Location

Loc Qty

Loc Code

ST272

13

65879

1

66012

12

1

D3554-7  
Ball Stud

Manufactured No

120 Each

14.0000

1

2



11/3/7sf

Ball Stud

Location

Loc Qty

Loc Code

ST067

14

37674

4

65123

10

2

D3557-1  
Bracket

Manufactured No

120 Each

10.0000

1

2



11/3/7sf

(20)

Bracket

Location

Loc Qty

Loc Code

ST067

10

64452

10

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:16:59 AM

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Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

MS20426AD4-5

Purchased

No

120

Each

5,517.000

2



Rivet

## Location

## Loc Qty

## Loc Code

ST317

5517

6733

535

6874

4982

120

Each

32.0000

22

MS21042L08

Purchased

No



Nut

## Location

## Loc Qty

## Loc Code

ST300

32

116823

32

120

Each

2,522.000

2

MS21042L3

Purchased

No



Nut

## Location

## Loc Qty

## Loc Code

ST300

2522

115835

22

116391

900

116540

800

116549

800

11/3/11 SD

4 11/3/11 SD

327 11/17/08 11/3/11 SD

12 4 11/3/11 SD

(20)

4

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, March 03, 2011 10:16:59 AM

Page 7

Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

120

Each

998.0000

1

2



S<sub>12</sub> Nut



11/3/11 sf

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

972

115594

276

116105

496

116548

200

2

MS24694-S69

Purchased

No

120

Each

78.0000

1



S<sub>12</sub> Screw



11/3/11 sf

Location

Loc Qty

Loc Code

ST289A

78

112492

78

MS27039-08-11

Purchased

No

120

Each

41.0000

2

4



S<sub>12</sub> Screw



11/3/11 sf

Location

Loc Qty

Loc Code

ST290

41

116289

41

MS27039-1-25

Purchased

No

120

Each

63.0000

1

2



S<sub>12</sub> Screw



11/3/11 sf (24)

Location

Loc Qty

Loc Code

ST292

63

102602

63

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Thursday, March 03, 2011 10:16:59 AM

Page 8

Work Order ID: 66995

Parent Item: D350-600-249

Parent Item Name: Spacepod Upgrade



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H3

Purchased

No

120

Each

134.0000

2

4



Washer



11/3/17 sl pd

Location

Loc Qty

Loc Code

ST277

134

115935

34

116373

100

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X									D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-449	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

\* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

\*\* PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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